

Date:

Wednesday, 6/27/2007 1:08:23 PM

User:

Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 33221		
Estimate Number	: 11632		
P.O. Number	: <i>NIA</i>	Part Number	: D2971
This Issue	: 6/27/2007 S.Q. No. : <i>NIA</i>	Drawing Number	: D2971 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: <i>NIA</i>	Material	: <i>NIA</i>
Written By	:	Due Date	: 7/20/2007
Checked & Approved By	: <i>[Signature]</i> 06.28	Qty:	10 Um: Each
Comment	: Est B 02.11.04 Re-format; Ø0.875" x 0.058" was Ø0.625" x 0.065" KJ		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6T0.875W058

6061-T6 Tube .375 x .058W



Comment: Qty.: 0.2975 f(s)/Unit Total: 2.9747 f(s)

6061-T6 Tube .375 x .058W

Cut 6061-T6 (WW-T-700/6) Ø0.875" X 0.058" Wall

(M6061T6T0.875W.058)

Batch: *M7950*

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

as per Dwg D2971 & Folio FA288

DIP 07/07/09

(11)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 07/07/09

(11)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

gmk 07/07/09

(11)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS**C 07/07/09* (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 33221

Part Number: D2971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11
07107109

Job Completion



07107109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

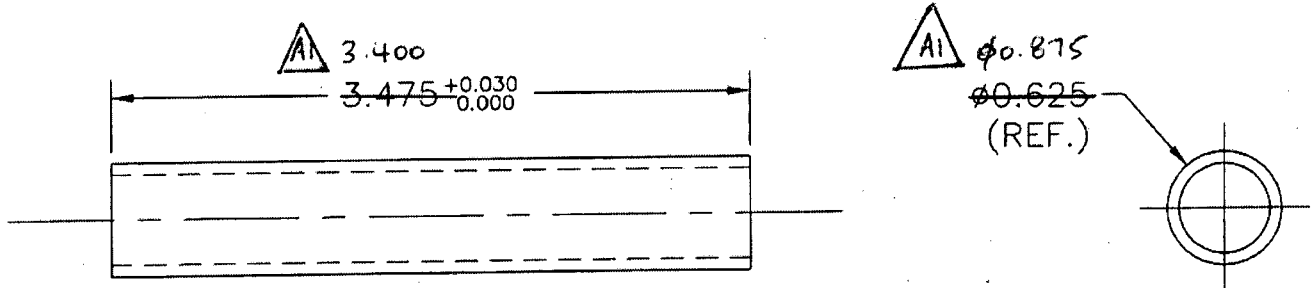
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2971	REV. A SHEET 1 OF 1
DATE 00.03.13		TITLE CROSS BOLT SPACER	SCALE 1:1
A	00.03.13	NEW ISSUE	
A1	4 UP 02.10.30	CHANGE TO 0.875 OD X 0.058 WALL	

RELEASED
00.05.11 [Signature]



MATERIAL: 6061-T6 (WW-T-700/6) 0.875 DIA X 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.875 DIA X 0.058 WALL
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33221

Copyright © 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	